

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018475**Date Inspected:** 29-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Travelers**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding, QC inspection and non-destructive testing of the Travelers.

Upon the arrival of the QA Inspector, the following observations were made:

**Traveler Test Rack**

On this date, the QA Inspector observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

See attached picture below.

**SAS-EB Traveler****Fixed Stairs Section**

On this date, the QA Inspector observed Westmont Industries (WMI) production welder, Mr. Jose Rodriguez (WID # 3031), continuing to perform Flux Core Arc Welding (FCAW) activities on the previously fit frame assemblies, identified as 10-A237, 11-B237, 3-A217, 4-A218, 5-A223 and 6-A224. The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.

**Lower Truss Section**

On this date, the QA Inspector observed Westmont Industries (WMI) production welder, Mr. Eutimo Lopez (WID # 3035), continuing to perform FCAW activities on the previously fit Frame assemblies, identified as 12-A240,

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13-B240, 7-A225, 8-A226 and 9-A230. The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.

See attached picture below.

### E2/E3-EB Traveler

On this date, the QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform FCAW welding activities on the intermediate and diagonal bracing Tube Steel (TS) material. The QA Inspector observed that the FCAW being performed by Mr. Jimenez appeared to be for the Frame Assemblies identified as 9-A332 and 10-B332, per the shop drawings. The QA Inspector observed that the weld joints appeared to be designated as fillet and flush flare groove welds and that Mr. Jimenez appeared to be performing the FCAW in the flat (1G) and vertical (3F) positions, throughout the shift. In addition to the above mentioned activities, the QA Inspector observed WMI Production fitter Mr. Cesar Canales and Raymundo Anaya (WID # 3196) performing layout, fitting and FCAW activities on tube steel and plate material, for the Frame Assembly identified as 14-A338, per the shop drawings.

The QA Inspector randomly observed that Smith-Emery QC Inspector Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, the QA Inspector observed that the applicable WPS's and copies of the shop drawings appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. The QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. The QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.



### Summary of Conversations:

On this date, the QA Inspector spoke with WMI Director of Quality Assurance Mr. Curtis Bell regarding the weld repairs on the SAS-EB Fixed Stairs section, Frame Assembly 6-A224.

The QA Inspector noted that the repairs were cracks previously discovered by the QA Inspector, during random Magnetic Particle Testing of the previously completed Fillet and Flare groove welds, on this Frame assembly. During conversation, Mr. Bell requested information from the QA Inspector, regarding these repairs. The QA

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Inspector explained to Mr. Bell that per AWS D1.1 2002, prior to performing repairs on cracks that the Engineer shall be notified. The QA Inspector observed Mr. Bell fill out form ABFWEST-QC-117.

The QA Inspector then explained to Mr. Bell that once the form is complete, submitted and reviewed by ABFJV that a photocopy could be provided to the QA Inspector and a Caltrans verbal approval might be possible for WMI to proceed with the above mentioned weld repairs. Mr. Bell then appeared to agree.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Vance,Sean	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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